

Work Order ID 129427

February-09-15 10:57:52 AM

129427

Page 1

Item ID: D2282-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: T Assembly
 Start Date: 2/09/15 Start Qty: 15.00 ***15*** Cust Item ID:
 Required Date: 2/27/15 Req'd Qty: 15.00 ***15*** Customer:
 Reference:

Approvals: Process Plan: U Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2282	Rev E

100 0.00

100 Large Fab
 Large Fab
 Large Fab
 Memo 0.00
 1-Weld as per D2282-041 'T' Handle Assembly
 Grind chamfers and ensure full penetration.as per dwg D2282
 *****brush weld right after welding, to take color off *****
 A/RER316L SS Filling Rod M/23823

22 EL 15-2-24

110 0.00

110 QC9- Inspect visual per QSI004- Fusion Welds
 QC Memo 0.00
 Quality Control

22 15-02-24

DAS
9
8-89

120 0.00

120 Small Fab
 Small Fab Memo 0.00
 Small Fab Tumble

22 15-2-24 DSC

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
130									
QC	Memo	0.00							
Quality Control									
									FEB 26 2015
140	Identify as per dwg & Stock Location: <u>GA</u>	0.00							DAS 06 9-89
140									
Packaging	Memo	0.00							
Packaging									
									FEB 26 2015
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

22

28

MCS 15-02-26

u 15-02-26

Picklist Print

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Parent Item: D2282-041

D2282-041

Parent Item Name: T Assembly

Start Date: 2/09/15

Required Date: 2/27/15

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2282-3		Manufactured	No			100	Each	34.0000	1	15			
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D2282-3

Tube

**

Q 15-2-24

Location

Loc Qty

Loc Code

WA002

34

109941

34

D2282-5

Manufactured No

100

Each

22.0000

1

15

D2282-5

Tube

**

Q 15-2-24

Location

Loc Qty

Loc Code

WA002

22

109942

22

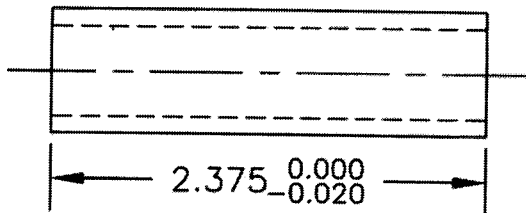
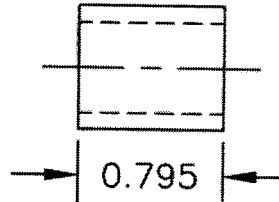
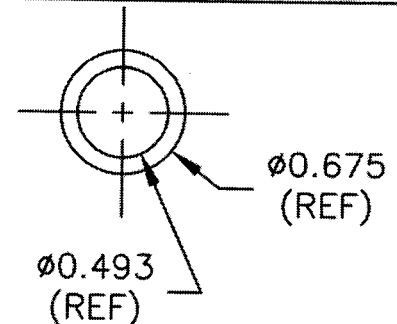
22

DART

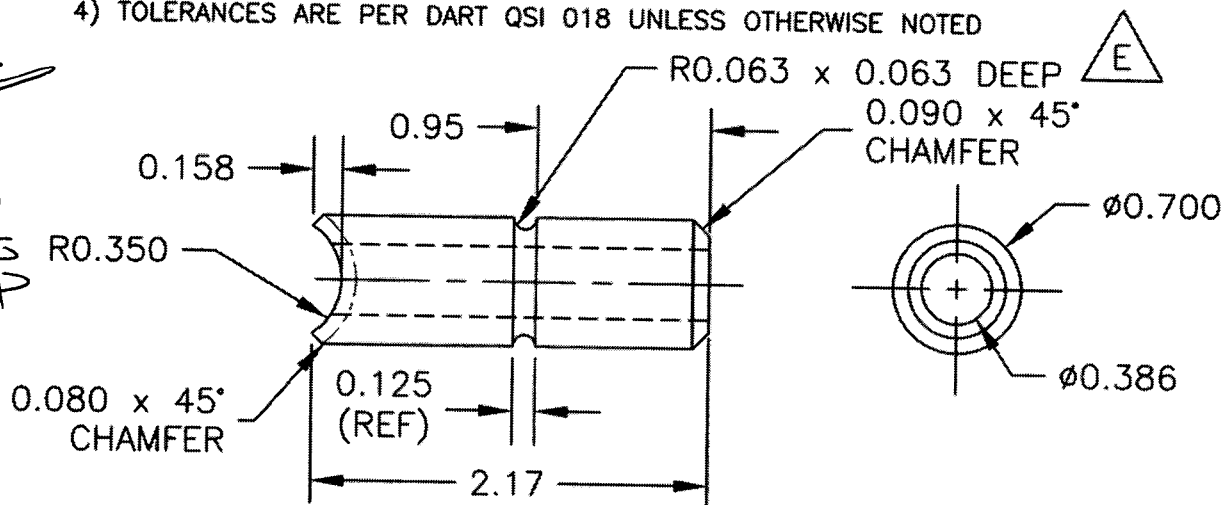
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED

05/09/16

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

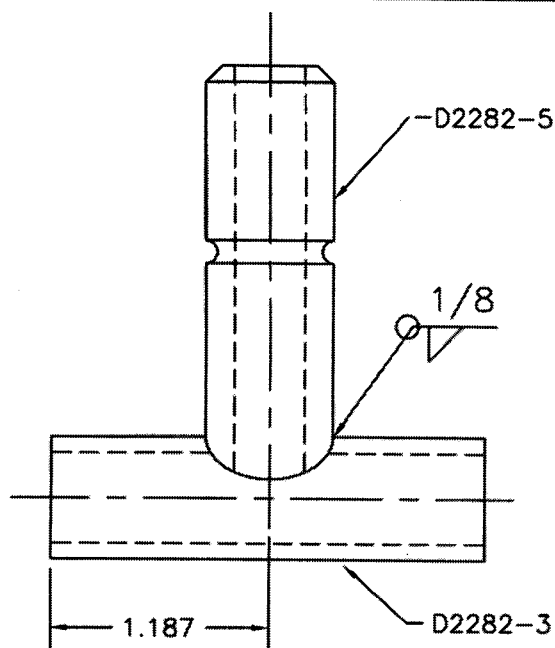
- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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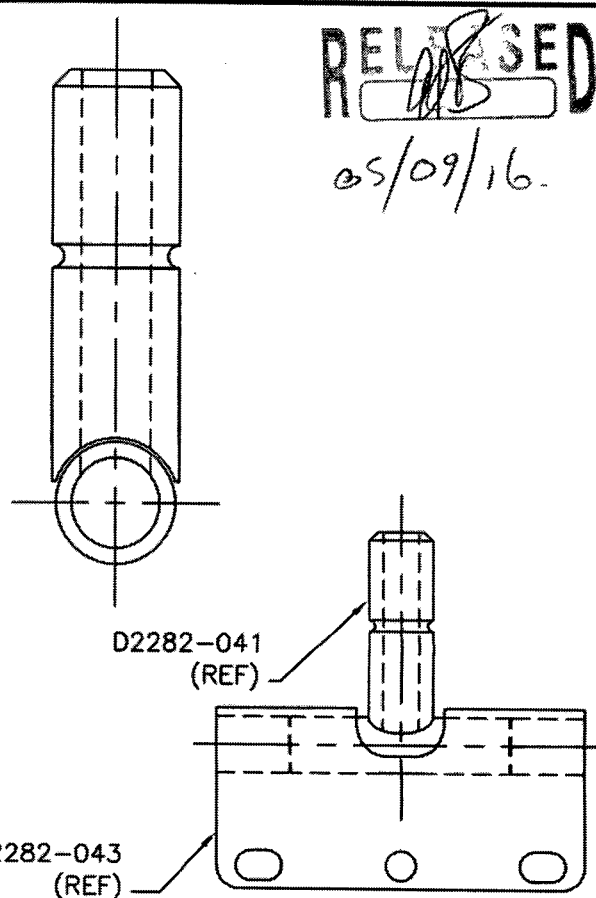
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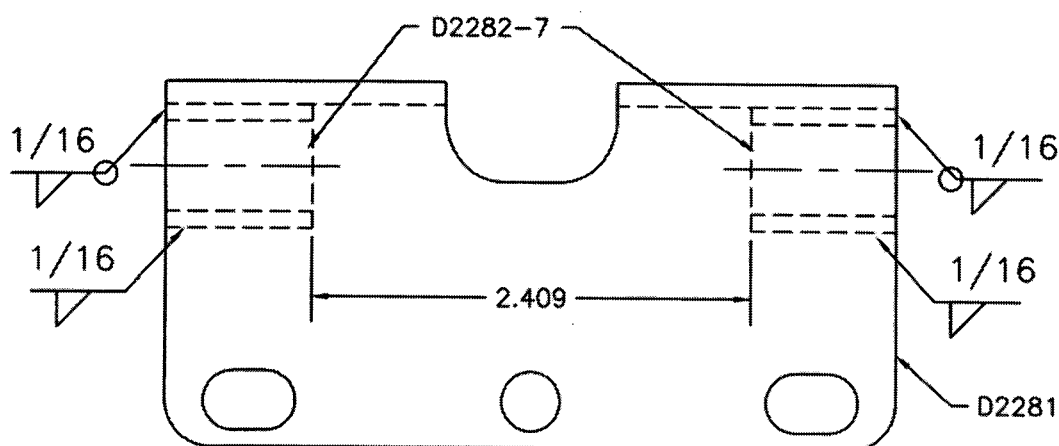
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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